

Work Order ID 76782

76782

Page 1

Monday, November 21, 2011 10:57:40 AM

Item ID: D2662-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH In 206
 Start Date: 11/21/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/10/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: P Date: 11-11-21 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								

100 0.00
100 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Program part number and batch number.
 Inspect part number and batch number are programmed
 MACHINE AS PER FOLIO FB068 & DWG
 DWG REV: D
 FOLIO REV: AA

SL 11-12-07

8

110 0.00
110 CONVENTIONAL MILLING MACHINE
 Mill Conv Memo 0.00
 Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet

SL 11-12-07

8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 1/10/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	SL	11-12-07		8	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	mk	11/12/07		8	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				8	0	11-12-81	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH In 206

Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 8-15								
	OVENTEMPERATURE: 320°F								
	FINISH TIME: 8-45								
160	QC3- Inspect Part Finish	0.00							
160									
QC		0.00							
Quality Control	Memo								
170	Identify as per dwg & Stock Location: 435	0.00							
170									
Packaging		0.00							
Packaging	Memo								

W/O:		WORK ORDER CHANGES					
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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH In 206

Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/10/2012 Req'd Qty: 8.00

8

Customer:

Reference:

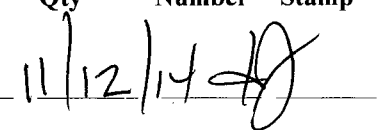
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/12/14 11-2-14
(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 21, 2011 10:57:46 AM

Page 1

Work Order ID: 76782

76782

Parent Item: D2662-1

D2662-1

Parent Item Name: Saddle, LH In 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.06.22Removed P/O for powder coatEC
IPP Rev:D As per Rev D 07-03-19 JLM IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	152.0000	1	8			
D6101-001									**				
Saddle Billet													

29 11-12-5

Location	Loc Qty	Loc Code
MAT040	152	
66965	1	
69677	2	
73774	60	
74648 ✓	21	
74679	68	

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 76782
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		-120	-120	-120	-120		
B	0.100	0.140		-131	-133	-134	-132		
C	1.125	1.145		1.136	1.136	1.136	1.136		
D	0.615	0.685		-685	-685	-685	-685		
E	0.240	0.260		-250	-250	-250	-250		
F	1.313	1.343		1.323	1.323	1.323	1.323		
G	0.210	0.230		-218	-218	-218	-218		
H	0.100	0.180		-140	-140	-140	-140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.576	1.576	1.576	1.576		
K	0.235	0.240		-237	-237	-237	-237		
L	0.100	0.120		-110	-110	-110	-110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		-512	-512	-512	-512		
O	5.990	6.010		5.999	5.999	5.999	5.999		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		-313	-313	-313	-313		
S	0.315	0.322		-316	-316	-316	-316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		-797	-797	-797	-797		
W	0.540	0.560		-551	-552	-550	-550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		-257	-257	-257	-257		
Z	0.912	0.932		-922	-920	-922	-920		
AA	0.490	0.510		-500	-498	-501	-500		
AB	0.178	0.198		-188	-188	-188	-188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: SL	Audited by: [Signature]
Date: 11-12-06	Date: 11/12/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 76768
Description: 206 Saddle, Inboard, Left side	Part Number: D2662-1
Inspection Dwg: D2662 Rev. D <u>5</u>	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

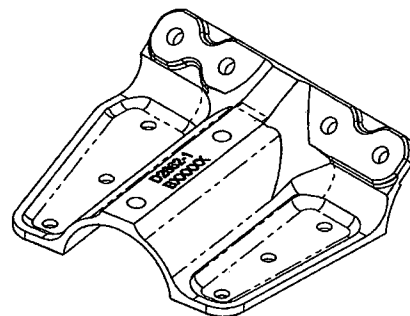
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/5	2/6	3/4	4/8	By	Date
A	0.100	0.140		-120	-121	-120	-120		
B	0.100	0.140		-132	-132	-133	-133		
C	1.125	1.145		1.136	1.138	1.136	1.137		
D	0.615	0.685		685	685	685	685		
E	0.240	0.260		250	249	249	250		
F	1.313	1.343		1.324	1.323	1.323	1.324		
G	0.210	0.230		219	219	218	219		
H	0.100	0.180		140	140	140	140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.576	1.578	1.576	1.577		
K	0.235	0.240		237	237	237	237		
L	0.100	0.120		110	110	110	110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		512	512	512	512		
O	5.990	6.010		5.999	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		313	313	313	313		
S	0.315	0.322		316	316	316	316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		797	797	797	797		
W	0.540	0.560		551	550	550	551		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		257	257	257	257		
Z	0.912	0.932		920	921	921	920		
AA	0.490	0.510		500	500	500	500		
AB	0.178	0.198		188	188	188	188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>SL</u>	Audited by: <u>cmk</u>
Date: <u>11-10-07</u>	Date: <u>11/12/07</u>

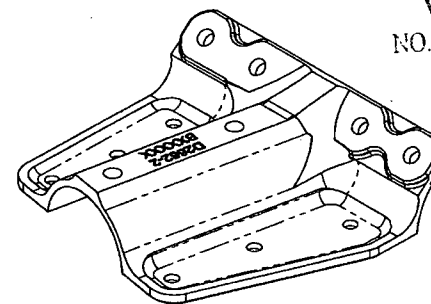
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO APPROVAL
 WITHOUT NOTICE
 WORK ORDER
 NO. 70782

PH-11-21



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

RELEASED
 2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (88-2,85-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP' DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>JP</i>		
CHECKED	<i>A.S.</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D2662	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

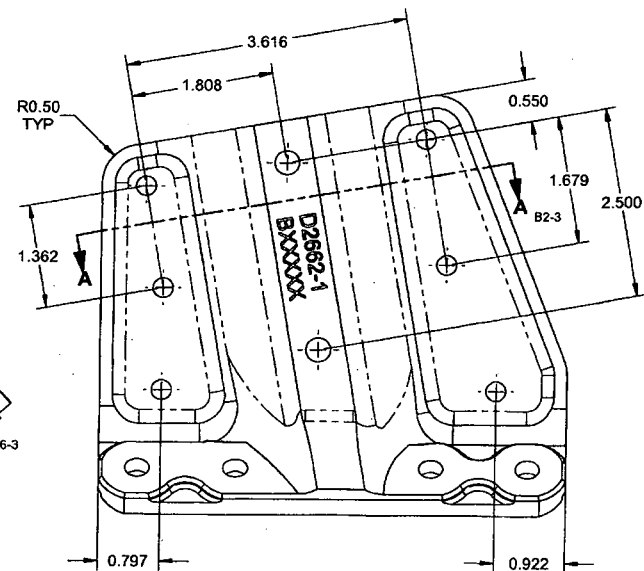
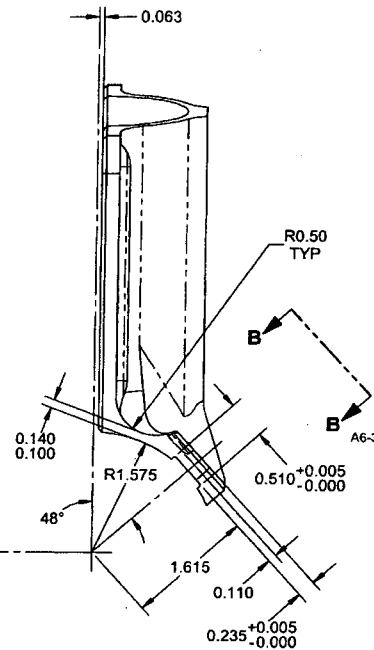
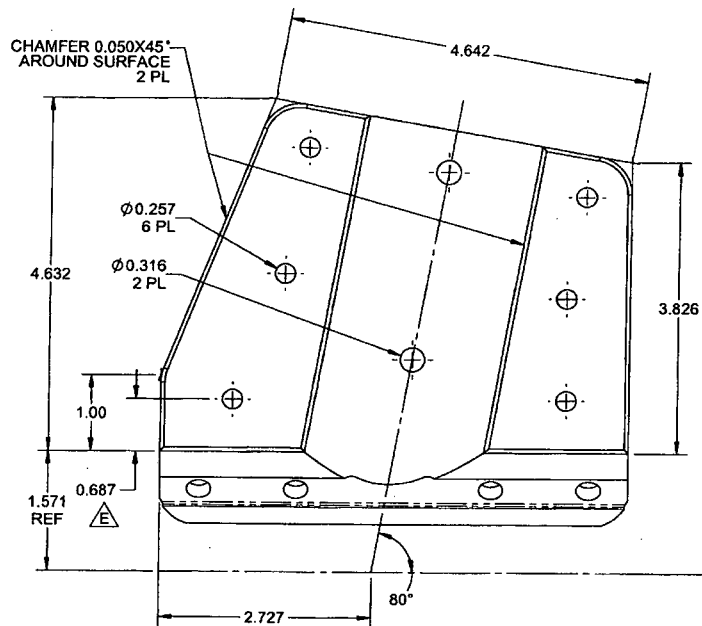
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2662-1 SADDLE, INSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRELIMINARY AND IS SUPPLIED BY THE TOP-LEVEL CONTRACTOR THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASE
2011-11-16

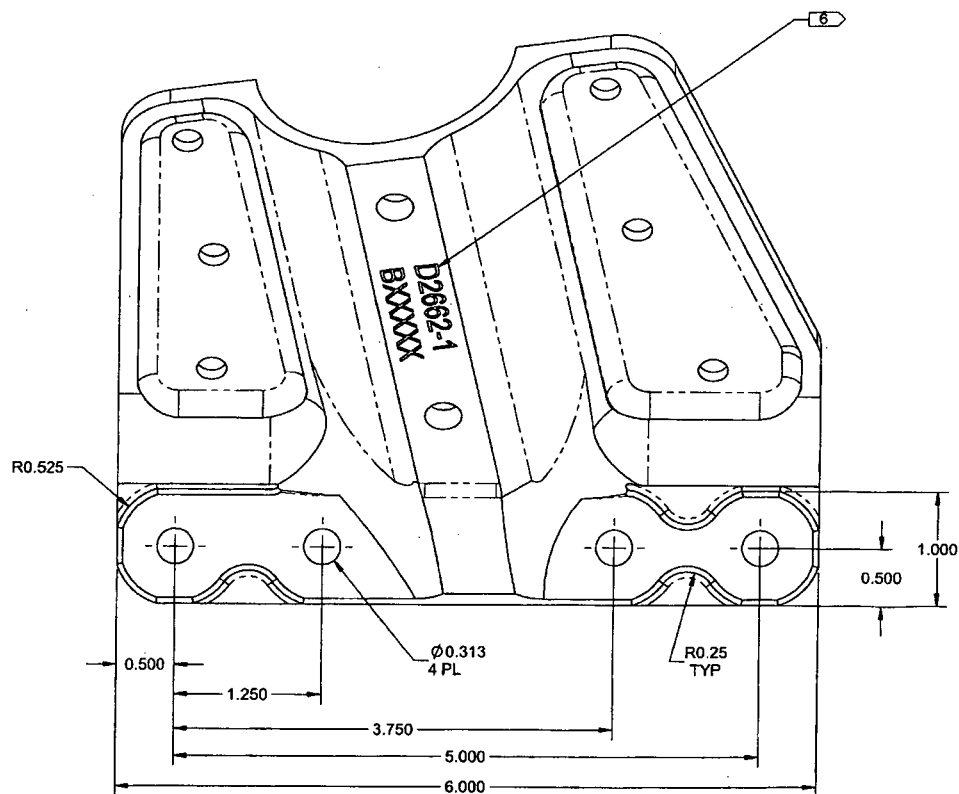
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

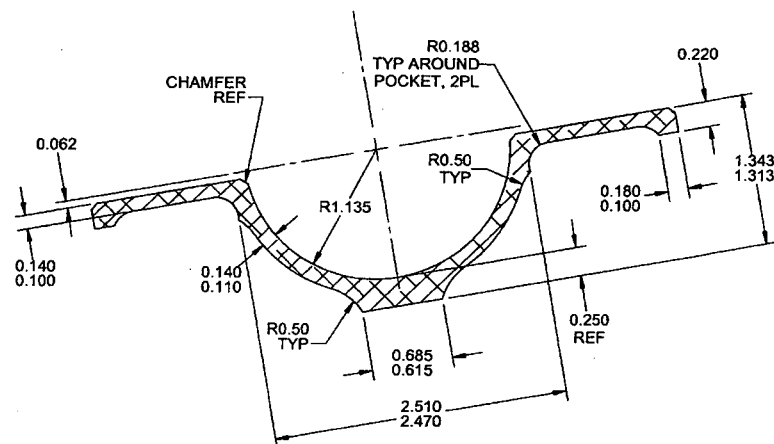
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VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A C1-2
SCALE 1.5X

RELEASED
2011-11-16

DESIGN	98	DART AEROSPACE USA, INC.	
DRAWN	98	KENT, WA	
CHECKED	ASS	DRAWING NO. D2662	REV. E
MFG. APPR.	3/16	SHEET 3 OF 5	
APPROVED	3/16	TITLE SCALE	
DE APPR.	3/16	SADDLE, INSIDE NTS	
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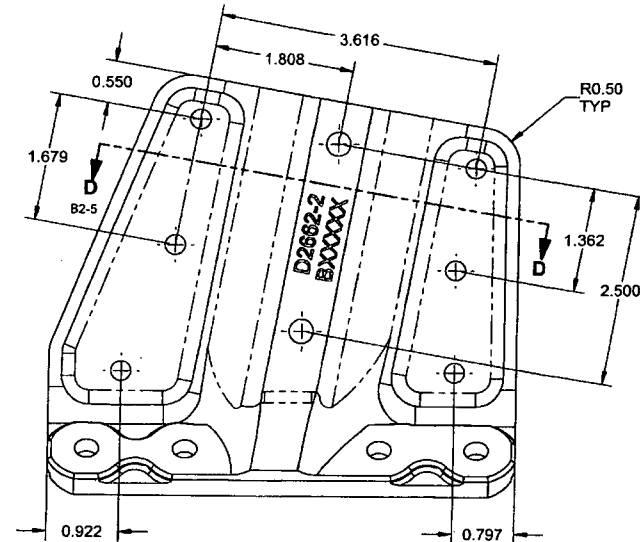
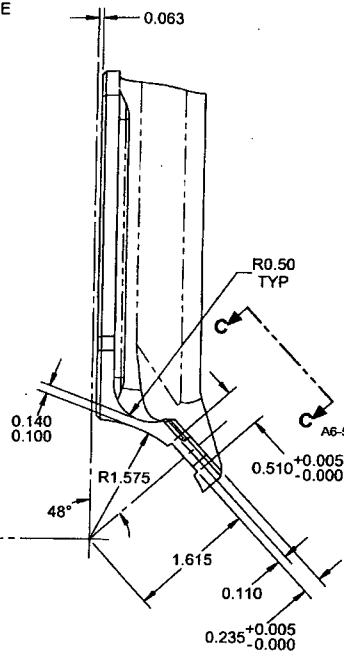
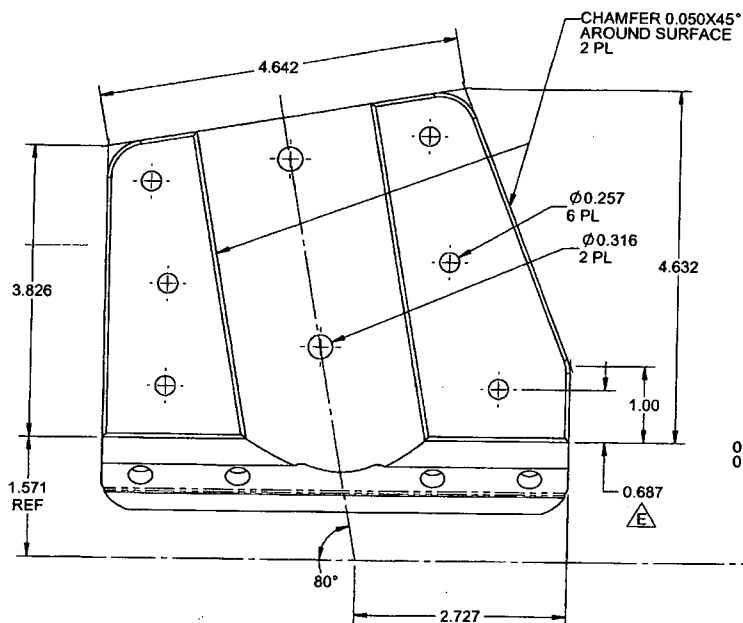
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RELEASED
2011-11-16

76782

D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

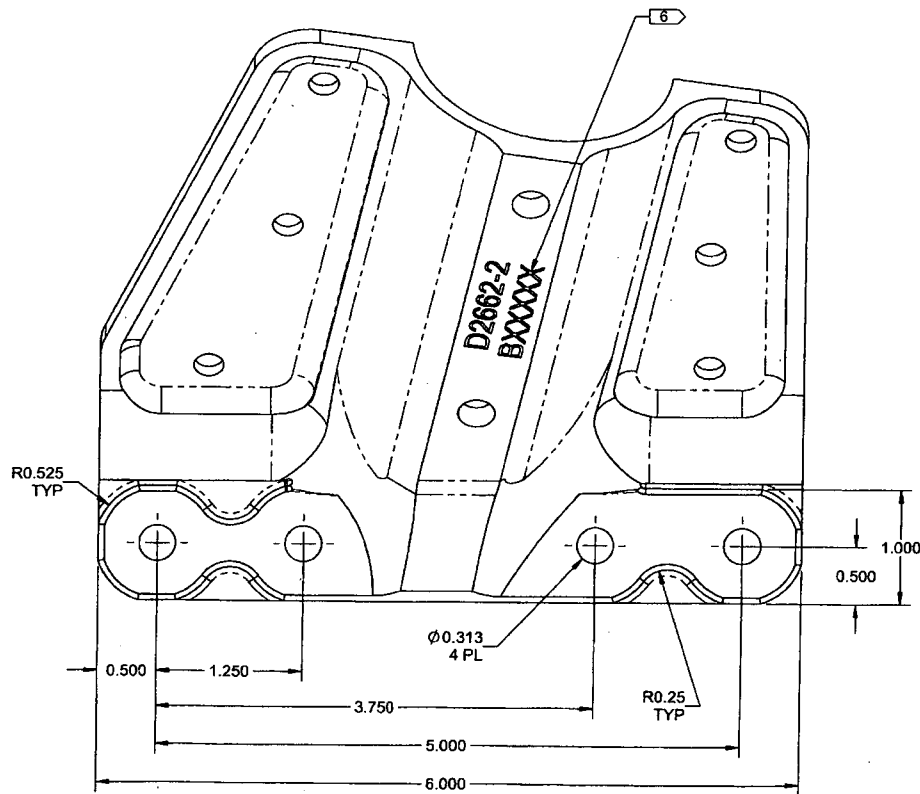
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

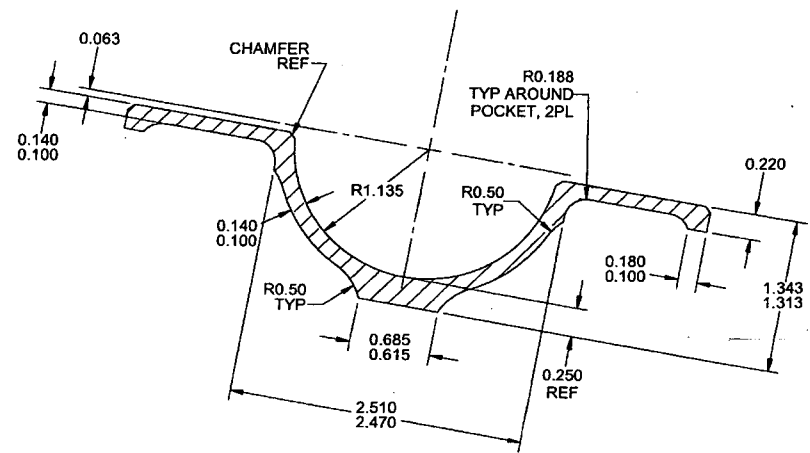
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



VIEW C-C C3-4
SCALE 1.5X

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries